



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

C3-7-2

Job Sheet 177505



Part No: C3-7-2

Job Qty: 20 ea

14

DAS
21
9-89

Part Name: Lock Bumper



Part Weight: 0 lbs

Status: At Planning

Scheduled

Priority: Medium

Job Created: 5/14/18

Job Tracking No:

Due Date: 5/31/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG C3-7-2 Rev A IPP Rev A 18.04.02 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	20 Ea	5/31/18	5/31/18	0.00	0.00	Start Up Small Fab-2		MLL
110	Small Fab	20 pcs	5/31/18	5/31/18	0.00	20.00	Small Fab-3		MLL DAS
120	QC	20 pcs	5/31/18	5/31/18	0.00	0.00	QC5		AUG 21 2018 38
130	Packaging	20 pcs	5/31/18	5/31/18	0.00	0.00	Packaging3-1		AUG 23 2018 38
140	QC21-SA	20 Ea	5/31/18	5/31/18	0.00	0.00	QC21		21 AUG 23 2018

Part Op 110 - 1-Mix 80A liquid urethane using base and activator as per manufacturer instructions. A/R; M 5048723
Descriptions: EXP. 3/19 2-Pour into appropriate mold. 3-Let cure as per manufacturer instructions. Time; 7:30am Date; 8/21/2018
7:30am 8/21/2018 4-Remove from mold. 5-Chamfer ends as per DWG. 6-Deburr if required. 8/21/2018 20

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
8644K12	80A Liquid Urethane	.0200 pcs (.001 ea)	90-Start up Operation	510326

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	8644K12	0	1	0

Part Specifications

Specifications could not be found.

Plex 5/14/18 11:32 AM Dart.lajeunesse.marie

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

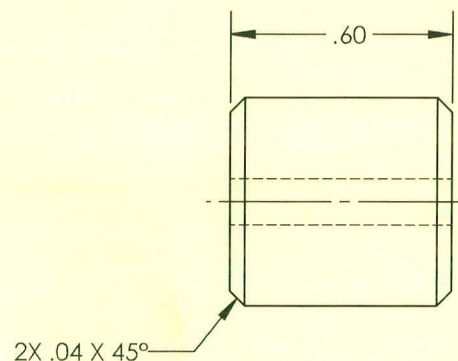
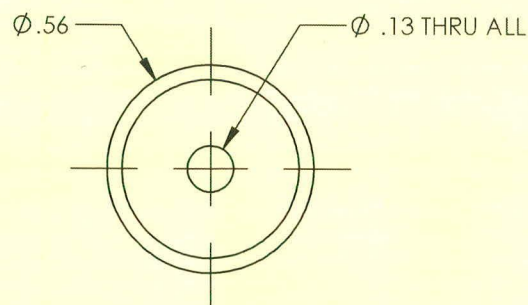
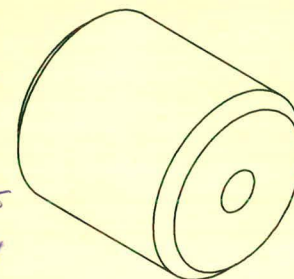
Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Water Jet ☐ Prod. Eng. Coord. ☐ _____ ☐ _____ ☐ Engineering ☐ Quality ☐ Other ☐																																																																																																													
Date : _____		Step #: _____		MRB (QSI042) Approval																																																																																																													
Description Work Order DART Aerospace Ltd. 1270 Aberdeen Street New Tecumseth, ON K6A 1K7 CANADA TEL: 1-613-632-5200 Email: sales@dartaero.com www.dartaero.com Container No: S10377 Part: C3-7-2 Job No: 177505 Serial No/Batch: S103777 Revision: A Inspector: _____ Exp Date: _____ Instructions: _____ Date: 08/21/18						Completed By _____ Lead hand / Supervisor Approval Verification _____ QC / QA Coordinator Approval _____																																																																																																											
Root Cause <table style="width:100%; border-collapse: collapse;"> <tr><td>Environment</td><td>☐</td><td>No Re-verification</td><td>☐</td></tr> <tr><td>Design</td><td>☐</td><td>Operator</td><td>☐</td></tr> <tr><td>Doc/Data</td><td>☐</td><td>Offset/Setup</td><td>☐</td></tr> <tr><td>Equip/Tooling</td><td>☐</td><td>Supplier</td><td>☐</td></tr> <tr><td>Handling/Pre</td><td>☐</td><td>Training</td><td>☐</td></tr> <tr><td>Material</td><td>☐</td><td>Use for Testing</td><td>☐</td></tr> <tr><td>Internal Transport</td><td>☐</td><td>Poor Information</td><td>☐</td></tr> <tr><td>Tribal Knowledge</td><td>☐</td><td>Rushing</td><td>☐</td></tr> <tr><td>LOA</td><td>☐</td><td>Product Improvement</td><td>☐</td></tr> <tr><td>Substation</td><td>☐</td><td>Process Improvement</td><td>☐</td></tr> <tr><td>Past Expiry Date</td><td>☐</td><td>Manufacturing Process</td><td>☐</td></tr> <tr><td>Misidentified</td><td>☐</td><td>Past Due</td><td>☐</td></tr> </table>		Environment	☐	No Re-verification	☐	Design	☐	Operator	☐	Doc/Data	☐	Offset/Setup	☐	Equip/Tooling	☐	Supplier	☐	Handling/Pre	☐	Training	☐	Material	☐	Use for Testing	☐	Internal Transport	☐	Poor Information	☐	Tribal Knowledge	☐	Rushing	☐	LOA	☐	Product Improvement	☐	Substation	☐	Process Improvement	☐	Past Expiry Date	☐	Manufacturing Process	☐	Misidentified	☐	Past Due	☐	<table style="width:100%; border-collapse: collapse;"> <tr><td>Pressur</td><td>☐</td><td>_____</td><td>☐</td><td>sitioned Wrong</td><td>☐</td></tr> <tr><td>Bending</td><td>☐</td><td>_____</td><td>☐</td><td>Outside Dimensions</td><td>☐</td></tr> <tr><td>Centre l</td><td>☐</td><td>_____</td><td>☐</td><td>Over/Under tolerance</td><td>☐</td></tr> <tr><td>Cracks</td><td>☐</td><td>_____</td><td>☐</td><td>Part Incorrect</td><td>☐</td></tr> <tr><td>Crimp/Ki</td><td>☐</td><td>_____</td><td>☐</td><td>Part Lost/Missing</td><td>☐</td></tr> <tr><td>Cuffs</td><td>☐</td><td>_____</td><td>☐</td><td>Part Moved</td><td>☐</td></tr> <tr><td>Crushing</td><td>☐</td><td>_____</td><td>☐</td><td>Drawing</td><td>☐</td></tr> <tr><td>Heat Treat</td><td>☐</td><td>_____</td><td>☐</td><td>Finish</td><td>☐</td></tr> <tr><td>Wave/Twist in Tube</td><td>☐</td><td>_____</td><td>☐</td><td>Misread</td><td>☐</td></tr> <tr><td>Marks/Chatter</td><td>☐</td><td>_____</td><td>☐</td><td>Turning Sequence</td><td>☐</td></tr> </table>				Pressur	☐	_____	☐	sitioned Wrong	☐	Bending	☐	_____	☐	Outside Dimensions	☐	Centre l	☐	_____	☐	Over/Under tolerance	☐	Cracks	☐	_____	☐	Part Incorrect	☐	Crimp/Ki	☐	_____	☐	Part Lost/Missing	☐	Cuffs	☐	_____	☐	Part Moved	☐	Crushing	☐	_____	☐	Drawing	☐	Heat Treat	☐	_____	☐	Finish	☐	Wave/Twist in Tube	☐	_____	☐	Misread	☐	Marks/Chatter	☐	_____	☐	Turning Sequence	☐
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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
A	14-0111	CH'D TITLE BLOCK WAS RED BARN IS DART. ADDED BAG & LABEL NOTE. CH'D DIMENSION TOLERANCE WAS Ø.563 IS Ø.56, WAS Ø.125 THRU ALL IS Ø.13 THRU ALL, WAS .600 IS .60.	8/7/2014	DJN	RW

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 177505 45
11/05/14



NOTE:
BAG & LABEL WITH BATCH NUMBER.

DART AEROSPACE	
TITLE LOCK BUMPER C3-HOOK	
DWG NO. C3-7-2	REV A
MAT'L POLYURETHANE	DRAWN BY: CANAM
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 .XX ± .01 .X ± .1	APPROVED <i>D Weil</i> HEAT TREAT FINISH SPEC
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	USED ON MODEL
SCALE 2:1	DATE 11/18/2001
SHEET 1 OF 1	

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
			C3-7-2	1	LOCK BUMPER	POLYURETHANE	POLYURETHANE	

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:15%;">Skid-tube ☐</td> <td style="width:15%;">Cross tube ☐</td> <td style="width:15%;">Water Jet ☐</td> <td style="width:15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																		
Description Work Order Deviation				Disposition				Completed By																	
								Lead hand / Supervisor Approval Verification																	
								QC / QA Coordinator Approval																	
Root Cause		FAULT CATEGORY																							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐																				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐																				
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